

Work Order ID 82882

\*82882\*

Page 1

April-10-12 2:38:15 PM

Item ID: D4406-041  
Revision ID:  
Item Name: Fwd Wearplate Assembly

Accept

\*N900040100\*

Setup Start \*NS1\*  
Stop \*NS2\*

Start Date: 10/04/2012 Start Qty: 8.00 \*8\*  
Required Date: 24/04/2012 Req'd Qty: 8.00 \*8\*

Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/04/10 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*  
Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4406	B

100 0.00

\*100\*

Waterjet

FLOW CNC Waterjet

304.050

Memo

1-Cut as per dwg D4406-1

prog rev: B

dwg rev: B

2-Deburr if required

0.00

B12-4-B



110 QC2- Inspect parts off machine FAI/FAIB 0.00

\*110\*

QC

Quality Control

Memo

0.00

B12-4-B

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 82882**

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**\*82882\***

Page 2

Item ID: D4406-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Fwd Wearplate Assembly

Start Date: 10/04/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Sizel 15

(K8)

Quality Control

130

0.00

**\*130\***

Small Fab

Memo

0.00

Small Fab

Form as per dwg D4406

8

SB  
12/04/12

140

QC5- Inspect part completeness to step on W/O

0.00

**\*140\***

QC

Memo

0.00

Sizel 15

(K8)

Quality Control




Sizel 15

# Dart Aerospace Ltd

W/O:		882882						WORK ORDER CHANGES	
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: 84406-041 PAR #: \_\_\_\_\_ Fault Category: long Feb / Design NCR: (Yes) No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: Repair Disposition: Re work QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/07/09	150	CRACKS FOUND WHERE HARD FACING BEAD IS ON 4 WEAR PLATES RAILS	 12.07.10 GSI02	Re Fuse crack's back to RAIL Re inspect Qc 9	MAL 12/07/10 CP 12.7.10 12/4/10	 12-07-10	 12/07/10	

NOTE: Date & initial all entries

# Work Order ID 82882

April-10-12 2:38:15 PM

**\*82882\***

Page 3

Item ID: D4406-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Fwd Wearplate Assembly

Stop **\*NS2\***

Start Date: 10/04/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
<b>*150*</b>									
Large Fab	Memo	0.00							
Large Fab	Weld bar as per dwg A/R 2059b hardcoat Batch#: <u>M122030</u>								
	Weld bar to wearplate as per dwg A/R s.s. rod Batch #: <u>M120013</u>								
160	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									
165	QC5- Inspect part completeness to step on W/O	0.00							
<b>*165*</b>									
QC	Memo	0.00							
Quality Control									

8x

MAL

12/07/09

8x

6/12/07-09

7/10 →

8x

8/12/07/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82882

April-10-12 2:38:15 PM

**\*82882\***

Page 4

Item ID: D4406-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Fwd Wearplate Assembly

Start Date: 10/04/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

**\*170\***

Small Fab

Memo

0.00

0.00

Small Fab

Apply coating as per dwg D4406

AC 12-07-12 (x8)

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC

Memo

0.00

Quality Control

DAS 16 12/07/13

(78)

190

Identify as per dwg & Stock Location: FP:1

0.00

**\*190\***

Packaging

Memo

0.00

Packaging

8 6 BL 10-7-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Work Order ID 82882**

April-10-12 2:38:15 PM

**\*82882\***

Page 5

Item ID: D4406-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Fwd Wearplate Assembly

Start Date: 10/04/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

QC21- Final Inspection - Work Order Release

0.00

**\*200\***

QC

Memo

0.00

Quality Control

cf 12/7/13

mf  
12-07-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April-10-12 2:38:24 PM

Page 1

Work Order ID: 82882

\*82882\*

Parent Item: D4406-041

\*D4406-041\*

Parent Item Name: Fwd Wearplate Assembly

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP rev A 11.06.06 new issue EC verified by:DD  
12.02.06 as per dwg revPB1 DD verf:EC

IPP rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S18GA

Purchased

No

100

sf

169.7860

3.5

29.47368

\*M304S18GA\*

304/316 .050 Sheet

\*\*

36.

B12-4-13

Location

Loc Qty

Loc Code

MAT020

158.786

119032

2.3

119383

33.486

119766

3

120604

120

176604

MAT20

11

121192

11

D4407-1

Manufactured

No

150

Each

14.0000

2

16

\*D4407-1\*

Bar

\*\*

Location

Loc Qty

Loc Code

WA

14

80758

8

82184

6

MAL

12/07/09

83312 X16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

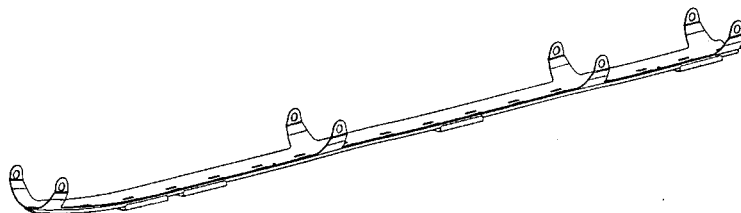
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

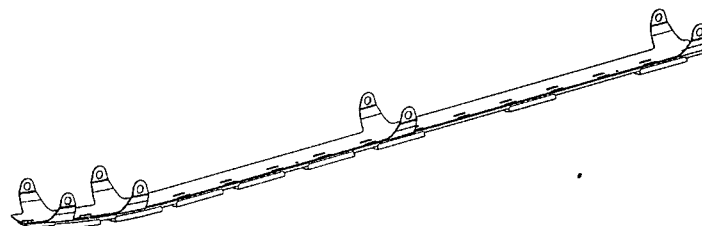
**NOTE:** Date & initial all entries







**D4406-041 FWD WEARPLATE ASSY**



**D4406-043 AFT WEARPLATE ASSY**

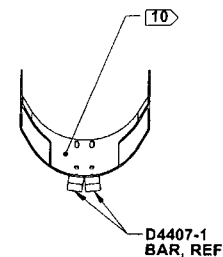
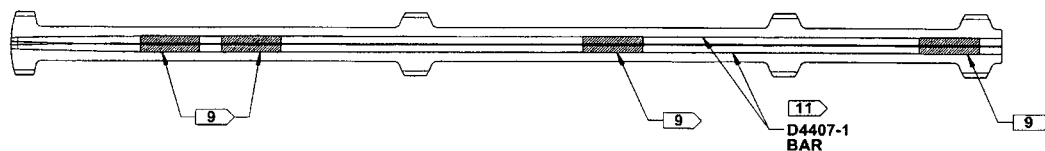
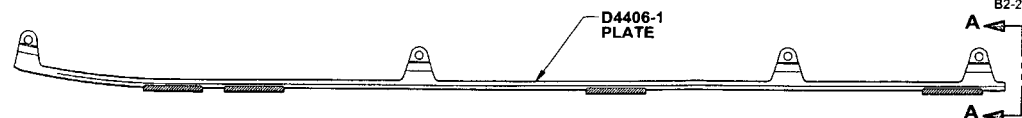
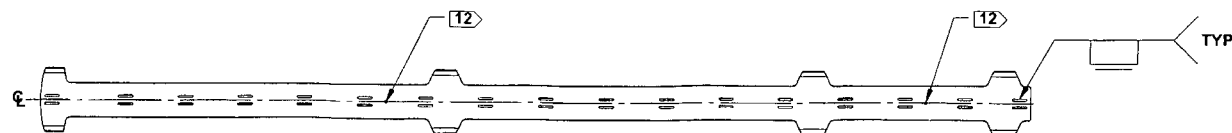
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D4406-041	FWD WEARPLATE ASSY
2		X	D4406-043	AFT WEARPLATE ASSY
3	1		D4406-1	PLATE
4		1	D4406-3	PLATE
5	2		D4407-1	BAR
6		2	D4407-3	BAR
7	A/R	A/R	2059B	HARDCOAT
8	A/R	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 10, SHT 2 & 3)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 82882 MLC  
12/04/10

RELEASE  
2012-02-23  
MD

B	REVISE BILL OF MATERIAL. ADD NOTE 13/14 & REVISE NOTE 9 SHT 2 & 3; MODIFY DETAIL E & F (ZN B3-6, C2-6); ADD DETAIL G (ZN C7-6); REVISE D4406-3F TAB LOCATIONS (ZN B5-5)	RF	12.02.16
A	NEW ISSUE	RF	11.08.15
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4406</b> REV. B SHEET 1 OF 6 TITLE <b>WEARPLATE ASSY</b> SCALE NTS DATE <b>12.02.16</b>	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



# **D4406-041 FWD WEARPLATE ASSY**

**SECTION A-A** C3-2  
SCALE 2X

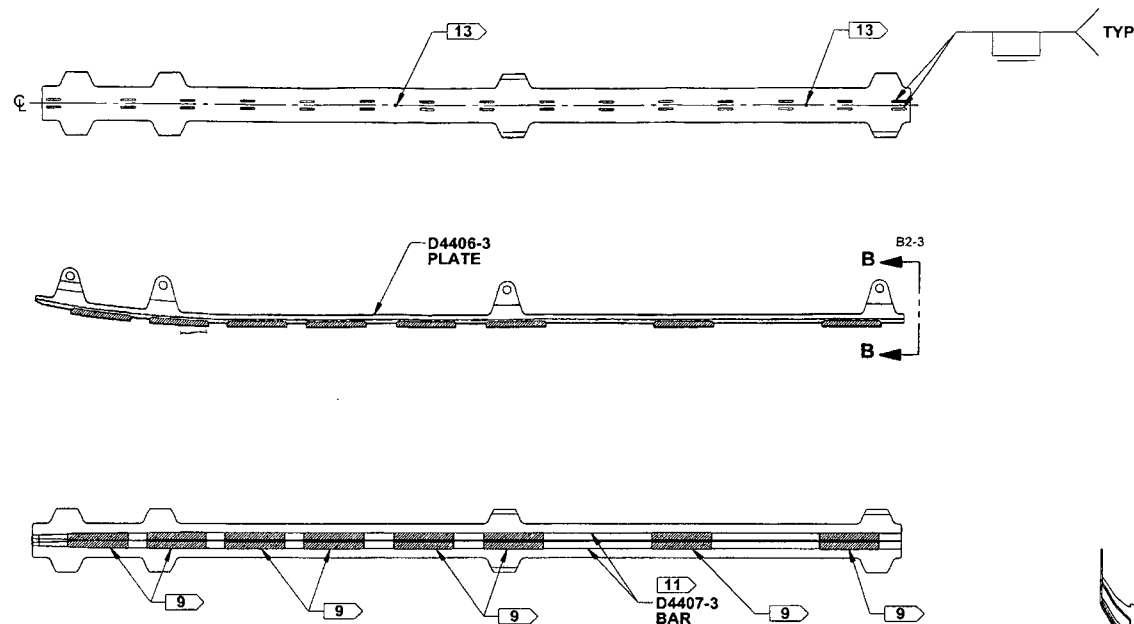
**RELEASED**  
2012-02-23  
MO

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.40 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.37 THICK x 0.50 WIDE, FLUSH WITH D4407-1 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-1 AT TIME OF WELDING
- 12) TRANSFER  $\varnothing 0.188$  HOLES FROM D4406-1 TO D4407-1
- 13) NOTCH D4407-1 BARS AS REQUIRED TO FORM TO D4406-1 PLATE

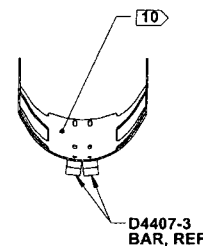
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DRAWN	RF		
CHECKED	RF	DRAWING NO. <b>D4406</b>	REV. B
MFG. APPR.	RF	SHEET 2 OF 6	
APPROVED	RF	TITLE <b>WEARPLATE ASSY</b>	SCALE
DE APPR.	RF	NTS	
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# **D4406-043 AFT WEARPLATE ASSY**

**SECTION B-B** C3-3  
SCALE 2X



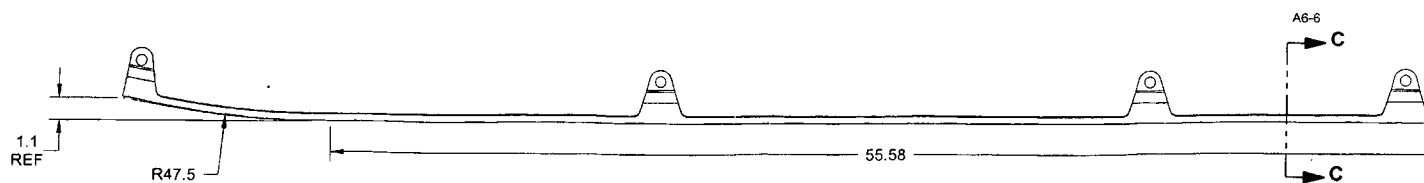
## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.73 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.37 THICK x 0.50 WIDE, FLUSH WITH D4407-3 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-3 AT TIME OF WELDING
- 12) FILL TOOLING HOLE WITH WELD ONE PLACE ONLY
- 13) TRANSFER  $\varnothing 0.188$  HOLES FROM D4406-3 TO D4407-3
- 14) NOTCH D4407-3 BARS AS REQUIRED TO FORM TO D4406-3 PLATE

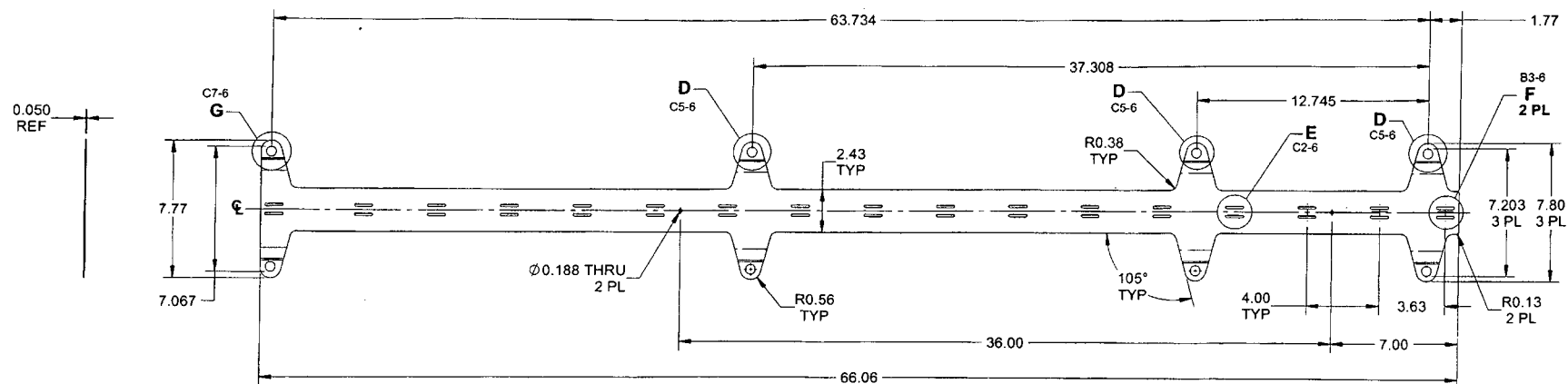


DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. <b>D4406</b>	REV. B
MFG. APPR.	RF		SHEET 3 OF 6
APPROVED	RF	TITLE <b>WEARPLATE ASSY</b>	SCALE NTS
DE APPR.	RF	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	12.02.16		

**RELEASED**  
2012-02-23



**D4406-1 PLATE**  
(MAKE FROM D4406-1F)



**D4406-1F FLAT PATTERN**

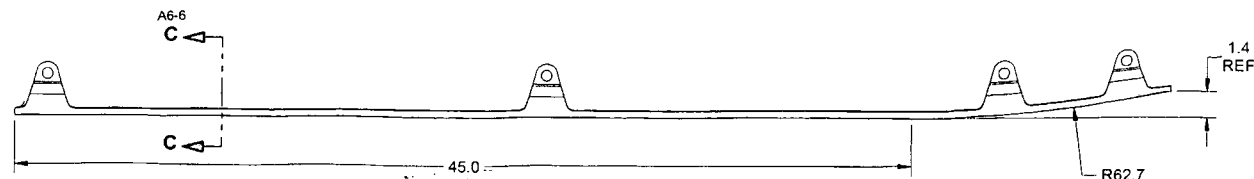
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)  
PER AMS 5513 OR 5524  
OR ASTM A240 OR ASME SA240  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.7 lbs

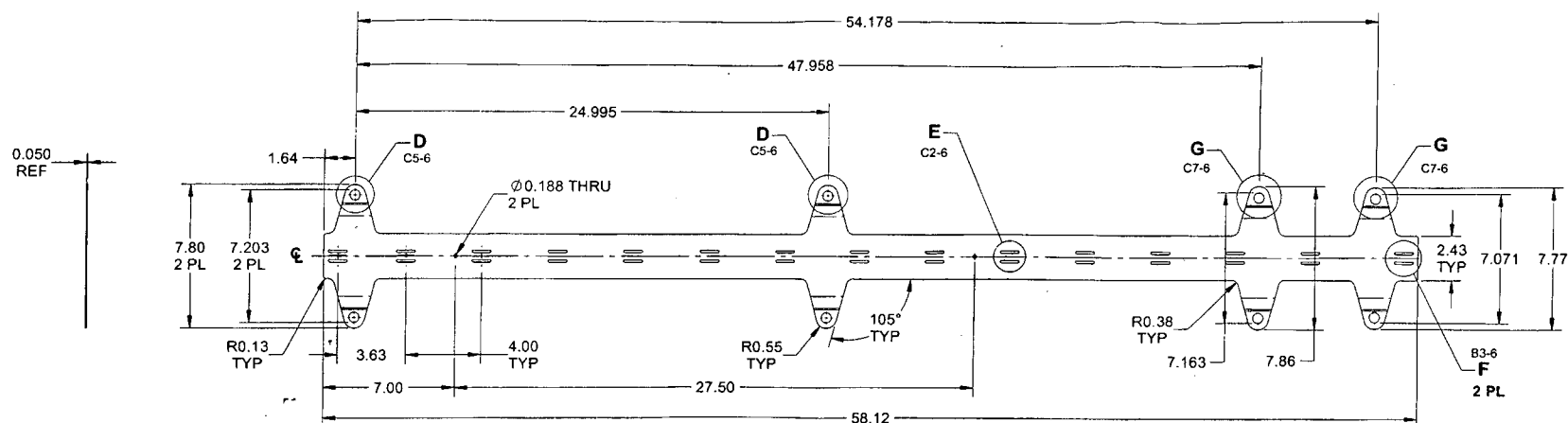
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R 2012-02-23  
MP

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	<b>D4406</b>	SHEET 4 OF 6
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	<b>WEARPLATE ASSY</b>	NTS
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02002



**D4406-3 PLATE**  
(MAKE FROM D4406-3F)



**D4406-3F FLAT PATTERN**

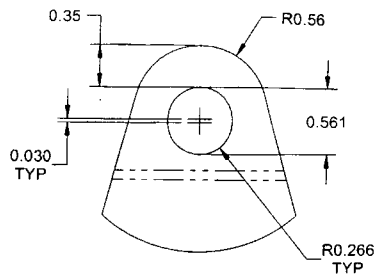
**RELEASED**  
2012-02-23

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)  
PER AMS 5513 OR 5524  
OR ASTM A240 OR ASME SA240  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.4 lbs

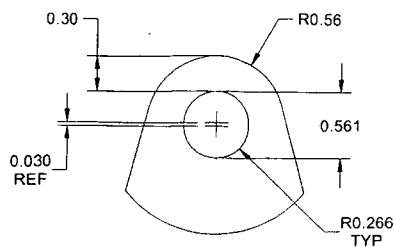
DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO. <b>D4406</b>	REV. B
MFG. APPR.	RF	SHEET 5 OF 6	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	<b>WEARPLATE ASSY</b>	NTS
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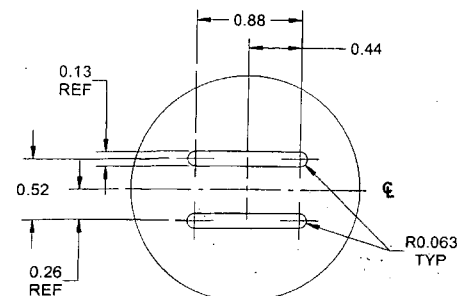
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C2-5  
C3-5



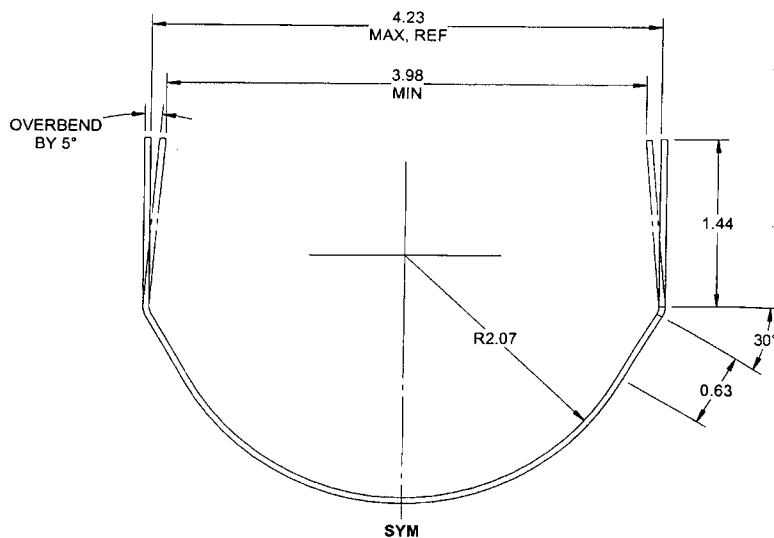
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C5-4  
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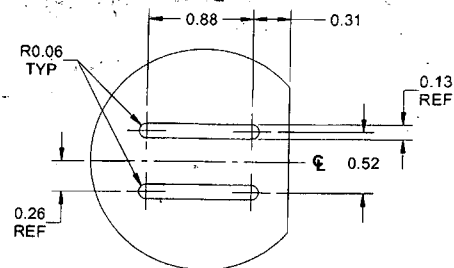
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C2-4  
C4-5



**DETAIL C**  
DETAIL TYP  
SCALE 6X

D2-4  
D6-5



**DETAIL F**  
SLOT DETAIL TYP  
SCALE 6X

C1-4  
B1-5

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